

Work Order ID 152380

Monday, October 24, 2016 11:18:41 AM

152380

Page 1

Item ID: D350-578-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AS350/AS355 Bearpaws

Start Date: 10/24/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 11/4/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: OCT 24 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-578

H

DAS
6
9-89

0.00

NOV 08 2016

DAS
21
9-89

10-11-083

100

Document Control

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-578-011 CHG006

3x DAS
28
9-89

NOV 17 2016

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

3x NOV 09 2016 DAS
26
9-89 DAS
27
9-89

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.02

Quality Control

3x DAS
28
9-89

NOV 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Work Order ID 152380

Monday, October 24, 2016 11:18:41 AM

152380

Page 2

Item ID: D350-578-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AS350/AS355 Bearpaws
Start Date: 10/24/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 11/4/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: <u>fgob</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.05							
Quality Control									

3x **DAS 27 28** **9-89 9-89** NOV 17 2016

DAS 21 9-89 NOV 17 2016

DAS 21 9-89 NOV 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Picklist Print

Monday, October 24, 2016 11:18:44 AM

Page 1

Work Order ID: 152380

152380

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2432

Manufactured No

160

Each

28.0000

2

6

D2432

Bearpaw 19" X 24"

**

B152453

Location

Loc Qty

Loc Code

ST

26

151377

12

151771

14

ST430A

2

147544

1

150373

1

NOV 09 2016

D2529

Manufactured No

160

Each

603.0000

12

36

D2529

Washer

**

Location

Loc Qty

Loc Code

ST008

603

150080

500

150996

103

36x

NOV 09 2016

D3601-1

Manufactured No

Each

29.0000

12

36

D3601-1

Radius Block

**

B15188 NOV 09 2016

Location

Loc Qty

Loc Code

ST045

29

150996

1

151014

28

DAS 6
9-89

NOV 09 2016

DAS 28
9-89

DAS 26
9-89
DAS 27
9-89

DAS 26
9-89
DAS 27
9-89

DAS 26
9-89
DAS 27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Page 2

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152380

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 3.00

Required Qty: 3.00

D4011-1 Manufactured No

Each 75.0000 6 18

D4011-1

Clamp, Short

DAS
28
9-89

Location

Loc Qty

Loc Code

ST544

75

151217

75

Each

93.0000

18

**

DAS
26
9-89
NOV 09 2016
DAS
27
9-89

D4012-1 Manufactured No

D4012-1

Cushion

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

133458

5

ST545

88

151095

46

151752

42

Each

148.0000

12 36

**

DAS
26
9-89
NOV 09 2016
DAS
27
9-89

AN4-16A Purchased No

AN4-16A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

143

M135704

43

M135774

100

36x

DAS
26
9-89
NOV 09 2016
DAS
27
9-89

DQA: _____ Date: _____



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D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0463J

Purchased

No

160

Each

2,230.000

24

72

NAS1149D0463J

Washer

DAS
26
9-89
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

cnc

200

M135671

200

GA

135

M134508

32

M135056

103

ST260a

1000

M135767

1000

ST263

895

M135530

95

M135671

800

72x

NOV 09 2016

MS21042L4

Purchased

No

160

Each

2,214.000

12

36

MS21042L4

Nut

DAS
26
9-89
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

260

m135058

260

OVER007

1500

m135774

500

m135864

1000

ST303

420

m135704

420

360x

NOV 09 2016

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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
12	12	12	12	12		D2529	Washer
				2		D2672F	Bearpaw
12	12	12	12	12		D3601-1	Radius Block (Replaces D2274)
					2	D3859-041	Wearplate
6	6	6	6	6		D4011-1	Clamp (Replaces D2438)
6	6	6	6	6		D4012-1	Cushion (Replaces D2182B050)
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-16A	Bolt
		12	12		12	AN4-17A	Bolt
24	24	24	24	24	24	NAS1149D0463J	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

Qty -111	Qty -113	Qty -115	Qty -117	Qty -121	Part Number	Description
X					D350-578-111	BEARPAW INSTALLATION
	X				D350-578-113	BEARPAW INSTALLATION
		X			D350-578-115	BEARPAW INSTALLATION
			X		D350-578-117	BEARPAW INSTALLATION
				X	D350-578-121	BEARPAW INSTALLATION
1					D350-578-011	Bearpaw Installation
	1				D350-578-013	Bearpaw Installation
		1			D350-578-015	Bearpaw Installation
			1		D350-578-017	Bearpaw Installation
				1	D350-578-021	Bearpaw Installation
1	1	1	1	1	D350-578-031	Wearplate Kit